

Multi-purpose Re-coatable Anti corrosive Epoxy Primer

SEAPOXY 73 is designed as a multipurpose primer for a variety of uses primarily for marine applications including immersion service and splash zone service. This product can also be used on all types of vessels and offshore equipment in salt corrosive atmospheres. It is specially designed to be used in conjunction with **SEA-SPEED V10X ULTRA CLEAR** Hard Film Siloxane Foul Release Coating.

It can be used on a multitude of substrates including:

- Steel
- Wood
- Gel Coat
- Fiberglass
- Non-ferrous metal

PREPARATION

1. If the craft has been in the water, remove the boat from the water and immediately high-pressure water blast in order to remove fouling.
2. Mechanically remove fouling by scraping followed by high-pressure water cleaning.
3. Remove all accessories from the hull such as trim tabs.
4. All surfaces must be washed to be free of dust, salt, dirt, oil and grease. Use compressed air to remove residual dust. If latent oils or grease are present, use MEK (Methyl Ethyl Ketone) or other high flash solvent to remove any contamination.
5. For atmospheric exposure, prepare substrate to minimum SSPC-SP6/NACE 3/Sa2 Commercial Blast Cleaning Standard; profile 2-3 mils (50-75 µm). For marine or immersion service, prepare the substrate to SSPC-SP10/NACE 2/Sa 2.5 Near-White Blast Cleaning; profile 2-3 mils (50-75 µm).
6. Thoroughly sand surface by hand or with an orbital sander using one eighty (180 grit) sanding disks. Chines and waterline are critical areas and special care should be taken to ensure those areas in particular are properly prepared.
7. If the existing epoxy barrier coat(s) are soft, brittle and poorly adhered or if osmosis is present the epoxy should be completely removed to bare gel coat surface. If Osmosis is present it should be addressed by a skilled professional prior to proceeding with any further application.
8. Mask off the surrounding areas to protect from over spray.
9. Protect the vessel from moisture (rain) and check the weather forecast. Prior to applying any paint you should protect all areas not to be coated. Apply a good quality masking tape or "Fine Line" for the waterline / boot-top.

PLEASE NOTE: Surface preparation is the key to a quality and successful finish. If you are not clear on the instruction, please call us.

SAFETY PRECAUTIONS

- It is important to protect yourself and the environment during preparation.
- Proper clothing such as disposable paper suits, goggles, a charcoal filter mask, a balaclava cotton hood and good quality dishwashing or chemical resistant disposable gloves.
- Protect the ground where you are working so that you can contain and collect residual paint dust and dispose of it according to local regulations.

This technical data sheet Jun 2020 supersedes those previously issued.

The Technical Data Sheet (TDS) is recommended to be read in conjunction with the Material Safety Data Sheet (MSDS) and the Application Guide (AG) for this product. Please visit our website at www.seacoat.com

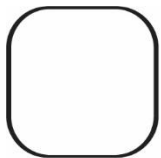
Date of issue: 1st June 2020

APPLICATION

- **SEAPOXY 73** is supplied in 2-gallon (7.57 litres) kit. The material is a 1:1 ratio by volume mix. 1 parts B (Base resin) to 1 part A (Activator). Mix necessary amount required to fill the gun and achieve a 7 mil (175 micron) wet film thickness per coat.
- Prior to applying any coating a survey of the bottom should be performed to check for cracks, leaks, blisters or grounding damage. Repair as necessary or contact a professional for an assessment and repair.
- If the existing barrier coat is in good condition, proceed to apply one or more coats of Epoxy barrier in order to achieve a dry film thickness (DFT) of 5 mils (125 microns) per coat. If all epoxy barrier coats have been removed, apply multiple coats of epoxy barrier coating to achieve a 10 mil (250 micron) dry film thickness (DFT) in order to ensure long term protection of the hull.
- Allow adequate cure times between coats of epoxy per manufacturers documentation.
- After the last coat of epoxy barrier is applied the epoxy shall be allowed to cure to a "Firm Thumbprint" stage. This is usually 4-8 hours. The last barrier coat should be cured to the point where you can press your thumb on the paint with 25-30 psi (.2 MPa) and barely leave a fingerprint. At that point you are ready to apply the **SEA-SPEED V10X ULTRA CLEAR**.

PROCEDURE AND TIMING

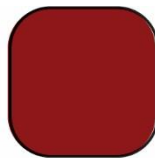
- Apply one coat **SEAPOXY 73** Epoxy barrier coat at 7 mils (175 microns) wet. Allow to cure overnight. Please review **SEAPOXY 73** Technical data sheet and MSDS prior to use.
- Next morning apply another coat of **SEAPOXY 73** Epoxy barrier coat at 7 mils (175 microns) wet. This should be the final desired color of the hull. Standard color choices are:



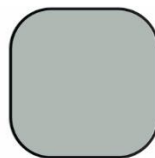
RAL 9003



RAL 9005



RAL 3005



RAL 7035



RAL 5005



RAL 6010

- **If applying the SEAPOXY 73 by spray** Allow the second coat of **SEAPOXY 73** to cure between 4-7 hours temperature dependent to a point it is a "Firm Thumbprint". This where you apply 25-30 psi pressure with your thumb and can barely leave a print.
- **If applying the SEAPOXY 73 by Roller** Allow the second coat of **SEAPOXY 73** to cure completely and sand smooth using 180 grit sandpaper.
- Apply one coat of SEA-SPEED V10X ULTRA CLEAR to the hull by:
 - a. Airless spray using a Graco FFLP (Fine Finish Low Pressure tip in size .308
 - b. Pressure pot with HVLP gun. A 1.4 or 1.6 mm tip should be used for best results.

~~ We have your bottom covered ~~

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